

Date: Tuesday, 7/18/2006 3:00:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE, OUTBOARD, LH, 206		
Job Number	: 27965		Part Number	: D26651		
Estimate Number	: 10818		Drawing Number	: D2665 REV. C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/18/2006 S.O. No. : N/A		Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 8/10/2006		
Previous Run	: 27588		Qty:	12	Um:	Each
Written By	: <i>J. Johnston</i> <i>Comments Below</i>					
Checked & Approved By	: <i>J. Johnston</i> 06.07.19					
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length Batch no <u>1325346</u>		
2.0	HAAS	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number <u>SA</u> 1-Inspect part number and batch number are programmed correctly 3-Fixturing Inspection last completed on <u>06.07.30</u> by <u>SA</u> 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No DQA: Date: 08/08/14

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 7/18/2006 3:00:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 27965

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SC 06/08/07 X 12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

SC 06/08/09 12

Acid etch and Alodine as per QSI 005 4.1

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

RM 06-08-10

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AL 06/08/11

FB

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST481

AL RB 06/08/11

12

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/08/14 12

Job Completion



CL 06/08/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

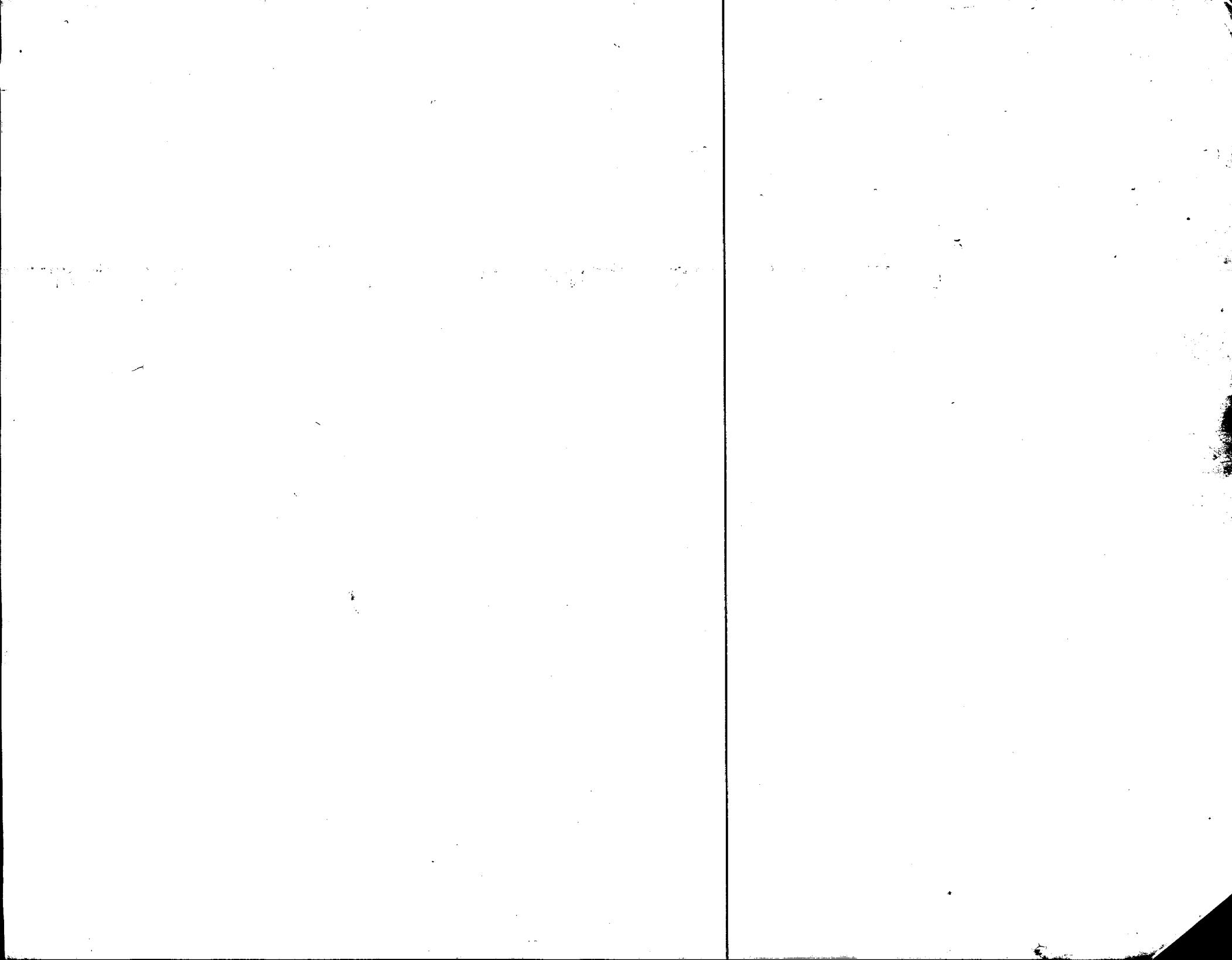
DART AEROSPACE LTD				Work Order: 27965	
Description: 206 Saddle, Outboard, Left side		Part Number: D2665-1			
Inspection Dwg: D2665 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.118	.117	.115		
B	0.100	0.140		.120	.120	.121	.121		
C	1.125	1.145		1.133	1.132	1.133	1.137		
D	0.615	0.685		.665	.655	.655	.655		
E	0.240	0.260		.251	.258	.250	.250		
F	1.313	1.343		1.323	1.323	1.324	1.324		
G	0.210	0.230		.220	.218	.218	.216		
H	0.100	0.180		.130	.130	.130	.130		
I	2.470	2.510		2.488	2.488	2.488	2.488		
J	1.565	1.585		1.573	1.570	1.571	1.568		
K	0.235	0.240		.238	.239	.237	.239		
L	0.100	0.120		.116	.119	.120	.120		
M	0.990	1.010		1.004	1.000	1.001	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.361		
V	0.787	0.807		.797	.797	.796	.796		
W	0.540	0.560		.548	.550	.549	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.921	.921	.922	.922		
AA	0.490	0.510		.499	.500	.500	.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD / J.L.	Audited by:	EN
Date:	06.07.31 / 06/08/01	Date:	06/08/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	JLM



DART AEROSPACE LTD

Work Order: 27965

Description: 206 Saddle, Outboard, Left side

Part Number: D2665-1

Inspection Dwg: D2665 Rev. C

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.117	.116	.111	.110		
B	0.100	0.140		.120	.121	.119	.119		
C	1.125	1.145		1.132	1.133	1.130	1.129		
D	0.615	0.685		.655	.655	.655	.655		
E	0.240	0.260		.251	.251	.246	.248		
F	1.313	1.343		1.325	1.325	1.322	1.324		
G	0.210	0.230		.218	.220	.211	.212		
H	0.100	0.180		.130	.130	.130	.130		
I	2.470	2.510		2.488	2.488	2.488	2.488		
J	1.565	1.585		1.570	1.571	1.568	1.567		
K	0.235	0.240		.239	.238	.238	.238		
L	0.100	0.120		.114	.113	.112	.111		
M	0.990	1.010		1.000	1.000	1.000	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.796	.797	.797		
W	0.540	0.560		.550	.550	.551	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.922	.922	.922	.922		
AA	0.490	0.510		.500	.500	.500	.499		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL	Audited by:	CP
Date:	06/08/01	Date:	06/08/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	SL

DART AEROSPACE LTD			Work Order:	27965
Description: 206 Saddle, Outboard, Left side			Part Number:	D2665-1
Inspection Dwg: D2665 Rev. C			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

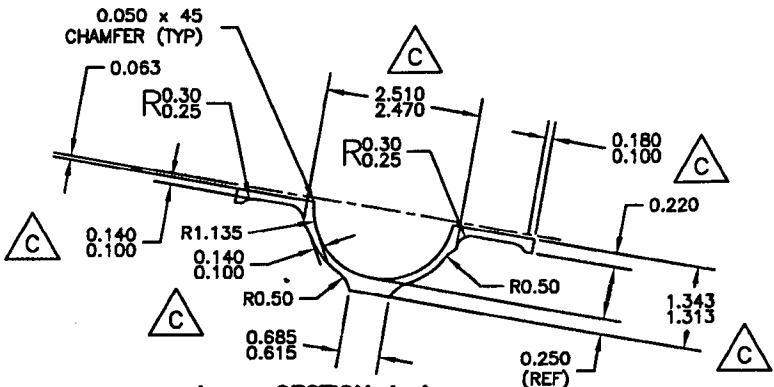
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.107	.107	.107	.112		
B	0.100	0.140		.120	.119	.120	.118		
C	1.125	1.145		1.130	1.130	1.128	1.136		
D	0.615	0.685		.655	.655	.655	.655		
E	0.240	0.260		.250	.248	.250	.243		
F	1.313	1.343		1.322	1.318	1.318	1.317		
G	0.210	0.230		.213	.211	.212	.213		
H	0.100	0.180		.130	.130	.130	.130		
I	2.470	2.510		2.488	2.488	2.488	2.488		
J	1.565	1.585		1.568	1.568	1.566	1.572		
K	0.235	0.240		.238	.239	.238	.238		
L	0.100	0.120		.112	.110	.112	.115		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		5.998	5.998	5.998	5.998		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.317	.317	.317	.317		
T	2.495	2.505		2.499	2.494	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.796	.796	.797		
W	0.540	0.560		.549	.550	.551	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.902	.902	.902	.902		
AA	0.490	0.510		.500	.500	.500	.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL	Audited by:	EN
Date:	06/08/02	Date:	06/08/02

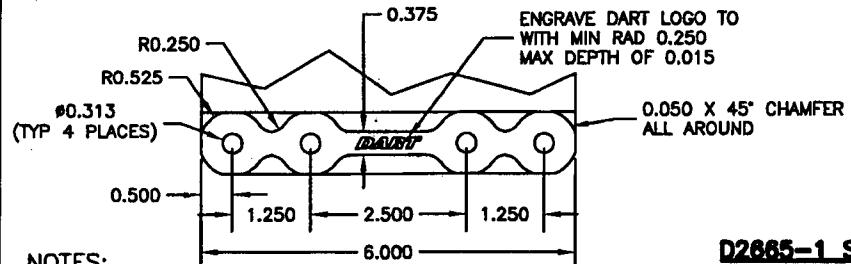
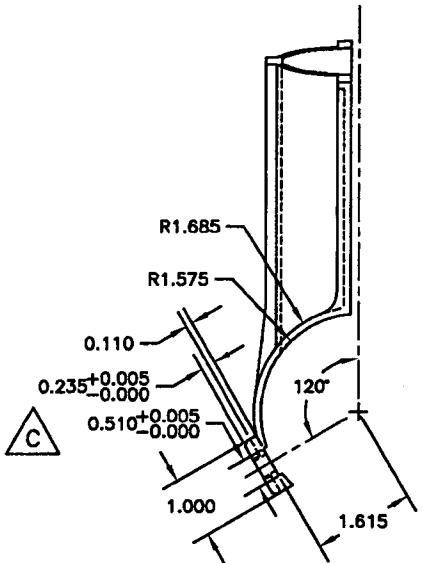
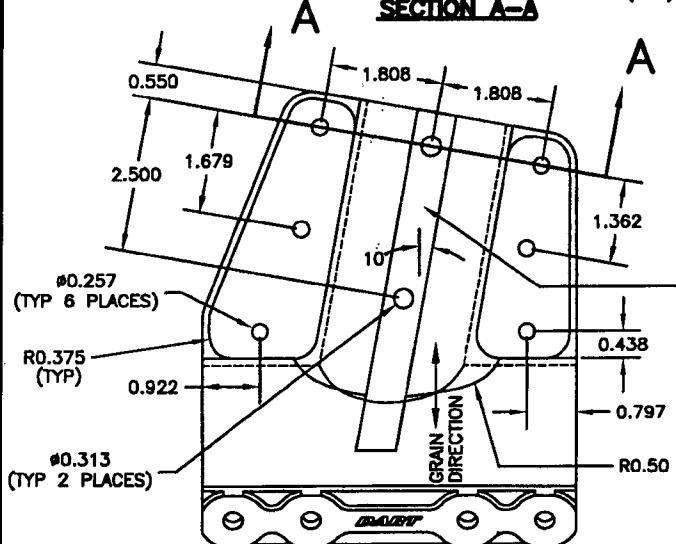
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	SL

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2665 REV. C
DATE		SHEET 1 OF 1
06.05.29		TITLE SADDLE FWD OUTSIDE HIGH
		SCALE 1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095



RELEASED
06.06.29



D2665-1 SADDLE FWD OUTSIDE HIGH

NOTES:

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27965

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